











April 27, 2010 1:43:13 PM

Item ID:	D3278-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Support					
Start Date:	27/04/2010	Start Qty: 40.00		Cust Item ID:		
Required Date:	04/05/2010	Req'd Qty: 40.00		Customer:		
Reference:						
Approvals:	Process Plan: 	Date: 10-4-27	Tooling:		Date:	
	QC:	Date:	SPC (Y/N):		Date:	
					Run	Start
					Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3278	Rev C								
100  Shear Shear	SHEAR Memo Cut blank: 2.00" x 1.00" x 2.550" long	0.00 0.00				40	0		
110  HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1- Machine as per Folio FA405 and Dwg D3278□2- Deburr and Tumble□Identify as D3278-2	0.00 0.00				40	0		
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				40	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 58184

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Page 3

Item ID: D3278-2

Accept



Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 27/04/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 04/05/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

(40) 10-5-6

170

Identify as per dwg & Stock Location: 48

0.00



Packaging

Memo

0.00

Packaging

10-5-6 (40) 10-5-6

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/07 MF 10-5-7

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NOTE: Date & initial all entries

Picklist Print

April 27, 2010 1:43:18 PM

Page 1

Work Order ID: 58184

Parent Item: D3278-2

Parent Item Name: Support

Comments: IPP: ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐

IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Start Date: 27/04/2010

Required Date: 04/05/2010

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	62.8300	9.8400			



6061-T6 Bar 1.00 x 2.00



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

60

114415

60

Main Warehouse

MAT03

2.83

112567

2.83

9.84 m 10/04/29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58184
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.100	✓			
0.359	+/-0.005	.361	✓			
0.609	+/-0.010	.615	✓			
0.250	+/-0.010	.249				
1.480	+/-0.005	1.480	✓			
R0.125	+/-0.010	.125				
0.119	+0.005/-0.004	.122	✓			
2.439	+/-0.010	2.440	✓			
1.980	+/-0.010	1.985	✓			
R0.13	+/-0.030	.125	✓			
Ø0.257	+0.005/-0.000	.259	✓			
R0.375	+/-0.010	.375	✓			
0.875	+/-0.010	.874	✓			
0.500	+/-0.010	.503	✓			
R0.400	+/-0.010	.400	✓			
R1.00	+/-0.030	1.00	✓			
1.720	+/-0.010	1.724	✓			
R0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.129	✓			

Measured by: J.B.	Audited by: H.A.	Prototype Approval:	N/A
Date: 10/08/03	Date: 10/05/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	BE

W/O:		WORK ORDER CHANGES					
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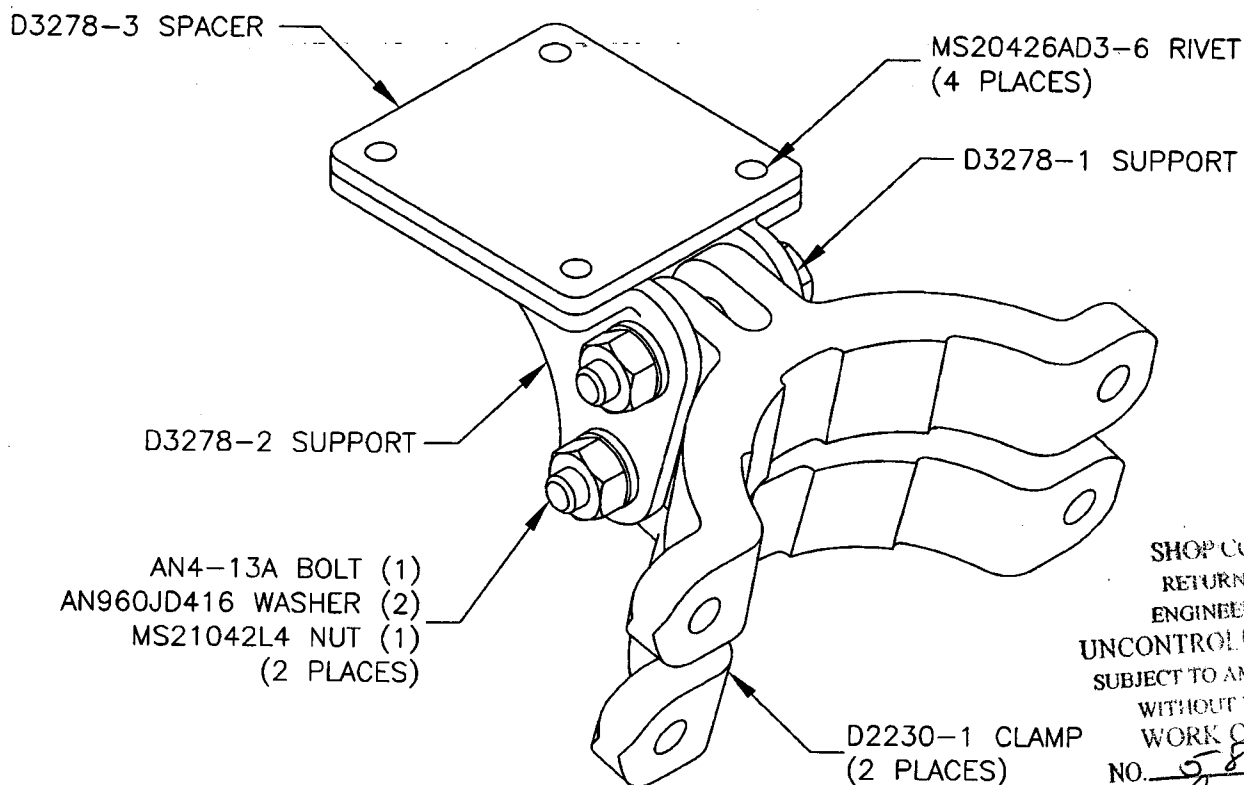
NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-06

D3278-041 SUPPORT ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58184
B810-4-27

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

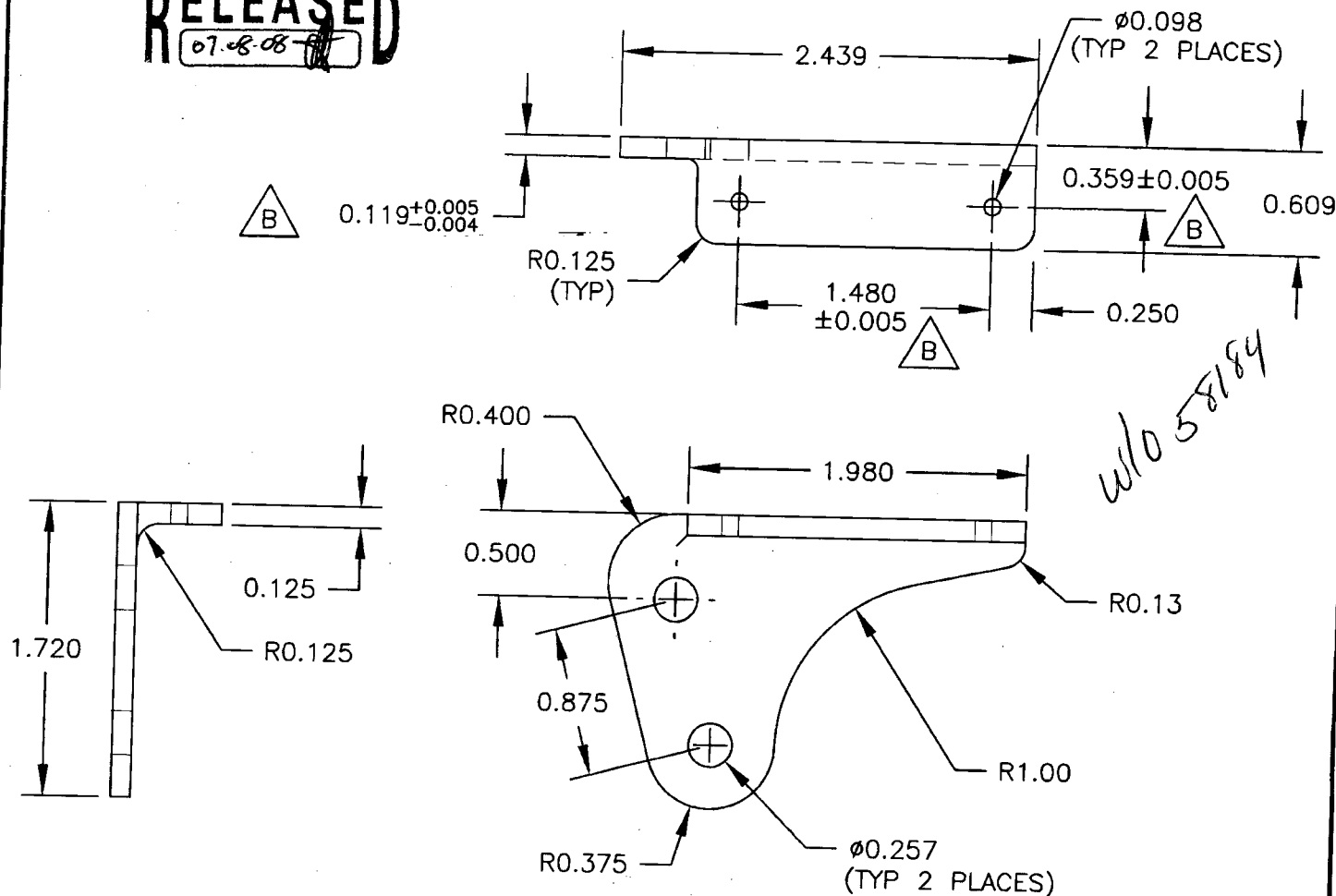
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NOTE: Date & initial all entries

DART

DESIGN <i>9P</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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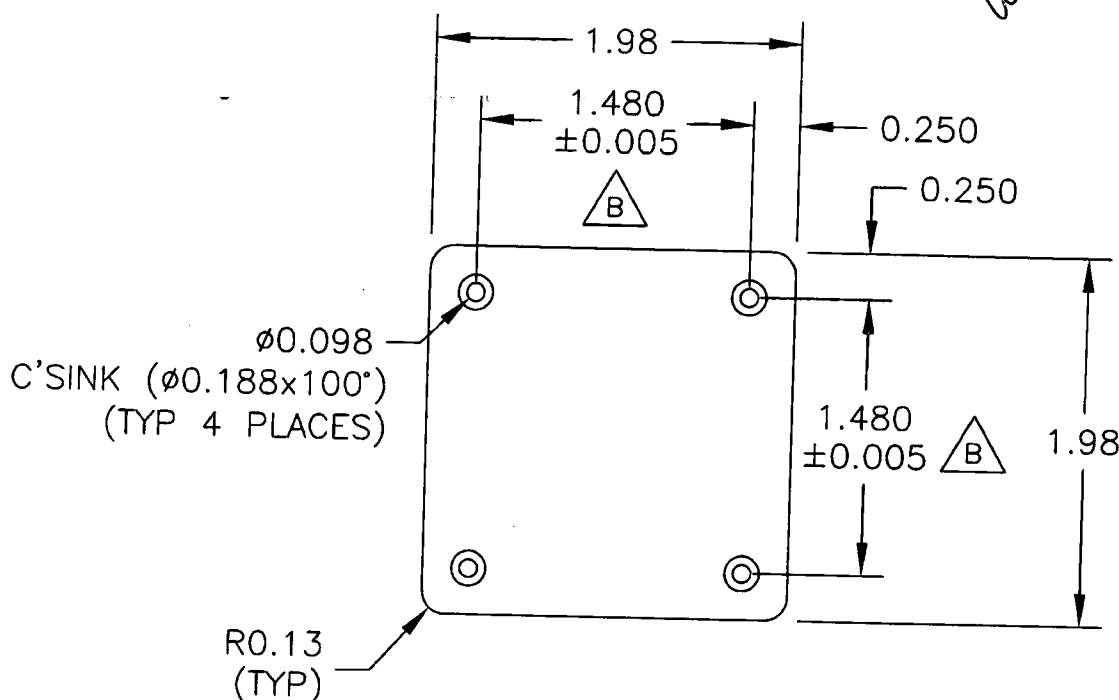
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NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08*w/o 58184***D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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